

Work Order ID 62918

Wednesday, October 13, 2010 12:58:26 PM



Page 1

Item ID: D3475-041

Accept



Setup Start



Revision ID:

Item Name: Dump Outlet

Stop



Start Date: 10/14/2010 Start Qty: ³2.00



Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-10-13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3475	Rev C								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D3479 2-Spot Weld as per Dwg D3475 and Dart QSI 018								
110		0.00							
	QC11- Inspect spot weld per QSI004								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

3X

⇒ m, l 10/10/18

SB 10/10/19

SB 10/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 10/14/2010 Start Qty: 2.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 059

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/14/19 B

10/10/19

MF
10-10-19

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 62918

Parent Item: D3475-041

Parent Item Name: Dump Outlet

Start Date: 10/14/2010

Required Date: 10/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 06-02-03 JLM
IPP Rev: B As per Rev B 06-05-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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NAS1031C3W

Purchased

No

100

Each

79.0000

8

16



Nutplate



m-f 10/12/18

Location

Loc Qty

Loc Code

ST297

79

106574

7

107139 ✓

72

24

23

D3475-3

Manufactured

No

100

Each

0.0000

1



Tube

B 62920



m-f 10/10/18 *

D3475-1

Manufactured

No

100

Each

0.0000

1



Outlet Adapter Plate

B 62919



23 m-f 10/10/18 *

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

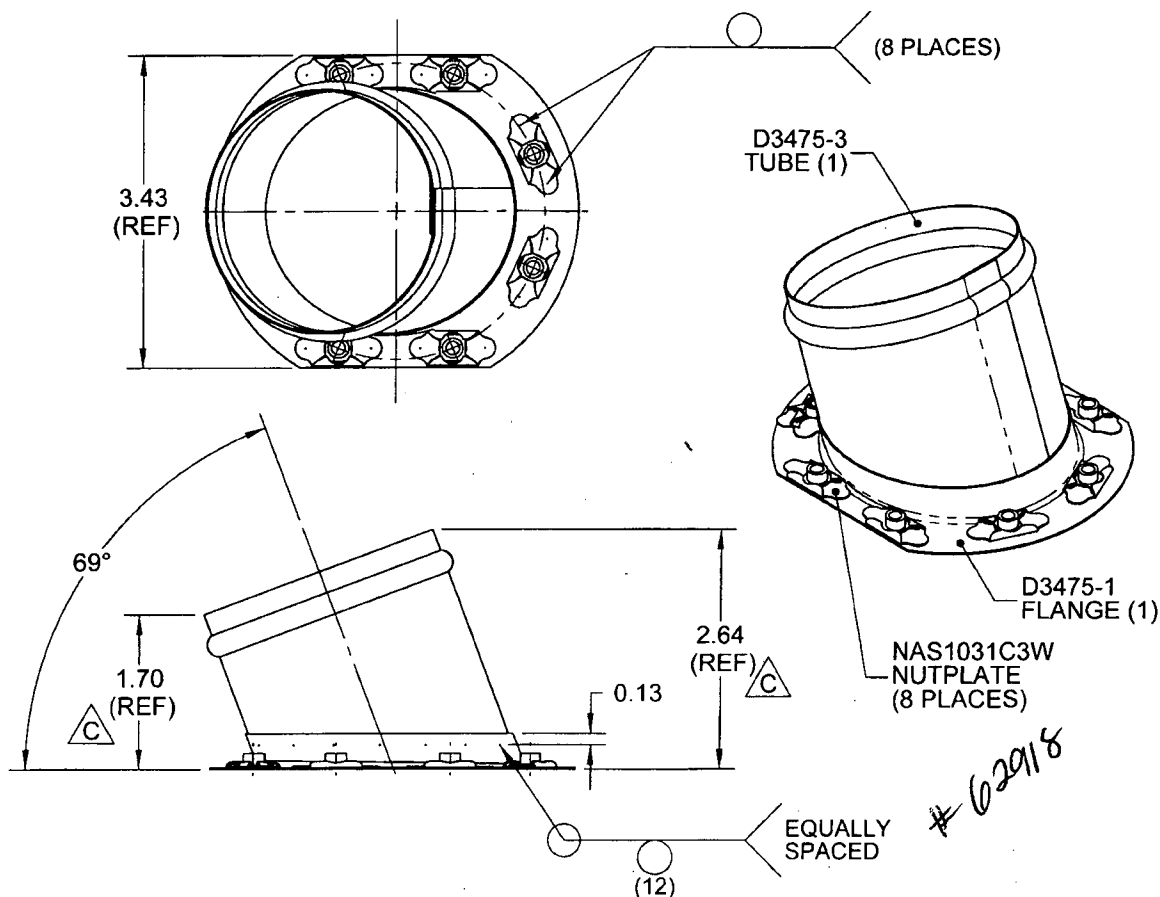
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3475	REV. C SHEET 1 OF 7
DATE 08.12.19		TITLE DUMP OUTLET	SCALE 1:2
A	06.01.24	NEW ISSUE	
B	06.05.16	REDESIGN D3475-1F/-5/-7S/-7; ADD D3475-9	
C	08.12.19	CORRECT DIMS PER D3475-3F; REMOVE $\varnothing 0.191$ HOLES ON D3475-7; MATL SPEC WAS MIL-S-5019	

**RELEASED**
09/01/30 M/S**D3475-041 DUMP OUTLET****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) IDENTIFY WITH DART P/N D3475-041 USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3475-041	DUMP OUTLET
1	D3475-1	FLANGE
1	D3475-3	TUBE
8	NAS1031C3W	NUTPLATE

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NOTE: Date & initial all entries

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 82

EMPLOYEE: Mar Gregory

PART NUMBER: D 3475-041

JOB NUMBER: 62918

MATERIAL TYPE: 304 ~~018~~

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 10/10/18

QUALIFIER: SB